HEMPADUR® MULTI-STRENGTH® 35530

BASE 35539 with CURING AGENT 95530

Description:

HEMPADUR MULTI-STRENGTH 35530 is a solvent-free, two-component, high-build, polyamine cured epoxy paint, which cures to a coating with good resistance to fresh water, sea water, crude oil, and to abrasion.
Applicable in thick coats by standard heavy duty airless spray equipment.
Harmless to grain cargo.

Recommended use:

1. As a heavy duty coating on steel exposed to abrasion where solvent-free materials are required. Full colour retention will be of secondary importance.
   If solvent containing paints are accepted, HEMPADUR MULTI-STRENGTH 45751 substitutes.
2. As a lining in potable water tanks and pipelines. Please see Certificates/Approvals.
   For application in warm climates. Please see APPLICATION CONDITIONS overleaf.

Service temperatures:

	Dry exposure only:	In fresh water (directly on steel):
Maximum:	140°C/284°F	35°C/95°F (no temperature gradient)

See REMARKS overleaf.

Certificates/Approvals:

Tested for non-contamination of grain cargo at the Newcastle Occupational Health, Great Britain.
Approved by Water Research Centre, Great Britain, for potable water up to 23°C/73°F.
Approved by Ministry of Electricity & Water, Bahrain, for potable water.

Availability:

Part of Group Assortment. Local availability subject to confirmation.

PHYSICAL CONSTANTS:

Colours/Shade nos:	Grey/10500 - Red/51320
Finish:	Semi-gloss
Volume solids, %:	100
Theoretical spreading rate:	3.3 m^2/litre - 300 micron 134 sq.ft./US gallon - 12 mils
Flash point:	> 100°C/212°F
Specific gravity:	1.3 kg/litre - 10.8 lbs/US gallon
Surface dry:	12 (approx.) hrs at 20°C/68°F *(ISO 1517)*
Dry to touch:	24 (approx.) hours at 20°C/68°F
Fully cured:	7 days at 20°C/68°F
V.O.C.:	0 g/litre - 0 lbs/US gallon

The physical constants stated are nominal data according to the HEMPEL Group's approved formulas. They are subject to normal manufacturing tolerances. The theoretical spreading rate has been calculated on the basis of a 100% solids volume.

APPLICATION DETAILS:

Mixing ratio for 35530:	Base 35539 : Curing agent 95530 3 : 1 by volume Stir CURING AGENT before adding it to the BASE.
Application method:	Airless spray Brush (touch up) *(Consult the separate APPLICATION INSTRUCTIONS)*
Thinner (max.vol.):	Do not dilute *(Consult the separate APPLICATION INSTRUCTIONS)*
Pot life:	1 hour (20°C/68°F) *(Consult the separate APPLICATION INSTRUCTIONS)*
Nozzle orifice:	.019" -.031"
Nozzle pressure:	min. 250 bar/3600 psi *(Airless spray data are indicative and subject to adjustment)*
Cleaning of tools:	HEMPEL'S TOOL CLEANER 99610
Indicated film thickness, dry:	300 micron/12 mils *(See REMARKS overleaf)*
Indicated film thickness, wet:	300 micron/12 mils
Recoat interval, min:	See REMARKS overleaf and separate APPLICATION INSTRUCTIONS
Recoat interval, max:	See REMARKS overleaf and separate APPLICATION INSTRUCTIONS

Safety:

Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult HEMPEL Material Safety Data Sheets and follow all local or national safety regulations. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.

HEMPADUR MULTI-STRENGTH 35530

SURFACE PREPARATION:

When used as a heavy duty coating or in potable water tanks and pipelines:
Abrasive blasting to min. Sa 2½ with a surface profile corresponding to ISO Comparator Rough Medium (G).Oil and grease must be removed with suitable detergent, salts and other contaminants by (high pressure) fresh water hosing prior to blasting. After blasting, clean the surface carefully from abrasives and dust.
On old steel surfaces having been exposed to salt water, excessive amounts of salt residues in pittings may call for abrasive blasting, high pressure fresh water hosing, drying, and finally, dry abrasive blasting again. Alternatively, water jetting may be used provided the steel surface has already the surface profile as described above.
Concrete: Remove slip agent and other possible contaminants by emulsion washing followed by high pressure hosing with fresh water. Remove scum layer and loose matter to a hard, rough and uniform surface, preferably by abrasive blasting, possibly by other mechanical treatment, flame cleaning or acid etching. Seal surface with suitable sealer, eg HEMPADUR SEALER 05990 (furthermore, please see Product Data Sheet for 05990).

APPLICATION CONDITIONS:

Use only where application and curing can proceed at temperatures above 10°C/50°F at all times until curing is completed. The temperature of the paint itself must be above 15°C/59°F for proper application. In-can temperature of the paint should preferably be below 25°C/77°F.
Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Relative humidity max 85%.
For application in warm climates, HEMPADUR MULTI-STRENGTH 45751 may preferably replace HEMPADUR MULTI-STRENGTH 35530 as a heavy duty coating. For potable water tanks and pipes please check local product assortment.

PRECEDING COAT: None, HEMPADUR SEALER 05990, HEMPADUR 15590 or according to specification.

SUBSEQUENT COAT: None, HEMPADUR or HEMPATHANE qualities as per specification.

REMARKS:

Certificates have been issued under the former quality number 3553.

Weathering/ service temperatures:

The natural tendency of epoxy coatings to chalk in outdoor exposure and to become more sensitive to mechanical damage and chemical exposure at elevated temperatures is also reflected in this product.

Film thicknesses:

May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoating interval. Normal range dry is 200-300 micron/8-12 mils.

Recoating:

Recoating intervals related to later conditions of exposure:
(300 micron/12 mils dry film thickness of HEMPADUR MULTI-STRENGTH 35530)

	Minimum		Maximum	
Surface temperature	20°C/68°F		20°C/68°F	
	Atmospheric	Water immersion	Atmospheric	Water immersion
Recoated with	Severe		Severe	
HEMPADUR HEMPATHANE	24 hours 12 hours	24 hours Not relevant	5 days 24 hours	5 days Not relevant

Mix and stir the two components until an even colour is achieved, where after the paint is ready for use. If improved colour stability is requested for exposure to sunshine, it is recommended to topcoat with e.g. HEMPATHANE TOPCOAT 55210.

Potable water tanks: See APPLICATION INSTRUCTIONS, as to time before taking into use and post treatment of coated surfaces to be in contact with potable water.

Note: **HEMPADUR MULTI-STRENGTH 35530 is for professional use only.**

ISSUED BY: HEMPEL A/S - 3553010500CO0003

This Product Data Sheet supersedes those previously issued.
For explanations, definitions and scope, see "Explanatory Notes" in the HEMPEL Book.
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